

Work Order ID 87546

July-19-12 1:18:07 PM

87546

Page 1

Item ID: D2534 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lock Plate
 Start Date: 7/12/12 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/20 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2534	Rev D								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2734 Dwg Rev: D Prog Rev: D 2-
 304 .125 Deburr if necessary
 37 3 Jm 12-8-1
 40 0

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
 37 3 Jm 12-8-1
 40 0

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
 37
 counts
 37
 SMPB 128.01
 DAS 16 9-03 12/08/11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Just Date: 12/08/13QA Closed: AS Date: 12/08/14

Work Order: <u>87546</u> Part No. <u>D2534</u> NCR No. <u>12-1659</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input checked="" type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>	12-8-1	100	3	3x pieces bent up while de-burring in de-burring machine. R.C. parts were passing inspection not as one shot. Parts are too small to be done this way as one operator error	DAS 16 9-89 057012	Scrap + destroy. No re-cut $2.13 \times 3 = 6.19$	JM 12-8-1	DAS 16 9-89 12/08/14	L 12-8-1 12/08/14																		
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY

Landing Gear

- ☐
- Bending
-
- ☐
- Centre Not Concentric to O/S
-
- ☐
- Cracks
-
- ☐
- Crushed/Crimped.
-
- ☐
- Cuffs
-
- ☐
- Heat Treat
-
- ☐
- Inspection Strip in Tube
-
- ☐
- Ripples in Bend
-
- ☐
- Torque Waves in Extrusion
-
- ☐
- Turning Sequence
-
- ☐
- Wave/Twist in Tube

General

- ☐
- Bend
-
- ☐
- BOM/Route
-
- ☐
- Broken/Damaged
-
- ☐
- Burrs
-
- ☐
- Contamination
-
- ☐
- Countersink
-
- ☐
- Cut Too Short
-
- ☐
- Drill Holes
-
- ☐
- Drawing
-
- ☐
- Finish
-
- ☐
- Folio

- ☐
- Grain
-
- ☐
- Hardware
-
- ☐
- Inspection Incomplete
-
- ☐
- Instructions Incomplete/Unclear
-
- ☐
- Maintenance
-
- ☐
- Mislabeled
-
- ☐
- Misread
-
- ☐
- Offset
-
- ☐
- Out of Calibration
-
- ☐
- Out of Sequence
-
- ☐
- Outside Dimensions

- ☐
- Ovalized
-
- ☐
- Over/Under tolerance
-
- ☐
- Part Incorrect
-
- ☐
- Part Lost/Missing
-
- ☐
- Part Moved
-
- ☒
- Positioned Wrong
-
- ☐
- Power Loss/Surge
-
- ☐
- Pressure/Forced
-
- ☐
- Temperature/Cure
-
- ☐
- Weld
-
- ☐
- Wrong Stock Pulled
-
- ☐
- Other

operator error

87546

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/12/12 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 7/27/12 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

Identify as per dwg & Stock Location: WA

0.00

130

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

34

12/12/25

12/8/3 ~~7~~

MLJ 12/08/02

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY				
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Picklist Print

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Page 1

Work Order ID: 87546

Parent Item: D2534

Parent Item Name: Lock Plate

Start Date: 7/12/12

Required Date: 7/27/12

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA		Purchased	No			110	sf	21.4760	0.0427	1797896			
304/316 0.125 Sheet										1.8			Jm 12-8-1

Location	Loc Qty	Loc Code
----------	---------	----------

MAT020

21.476

121380

9.65

121780

11.826

122521

122521

NCR: Yes / No

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FAULT CATEGORY				
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2534	REV. D SHEET 1 OF 1
CHECKED <i>##</i>	APPROVED <i>##</i>	TITLE LOCK PLATE	SCALE 1:1
DATE 04.12.14			
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED

04.12.16 *##*

SHOP COPY

RETURN TO

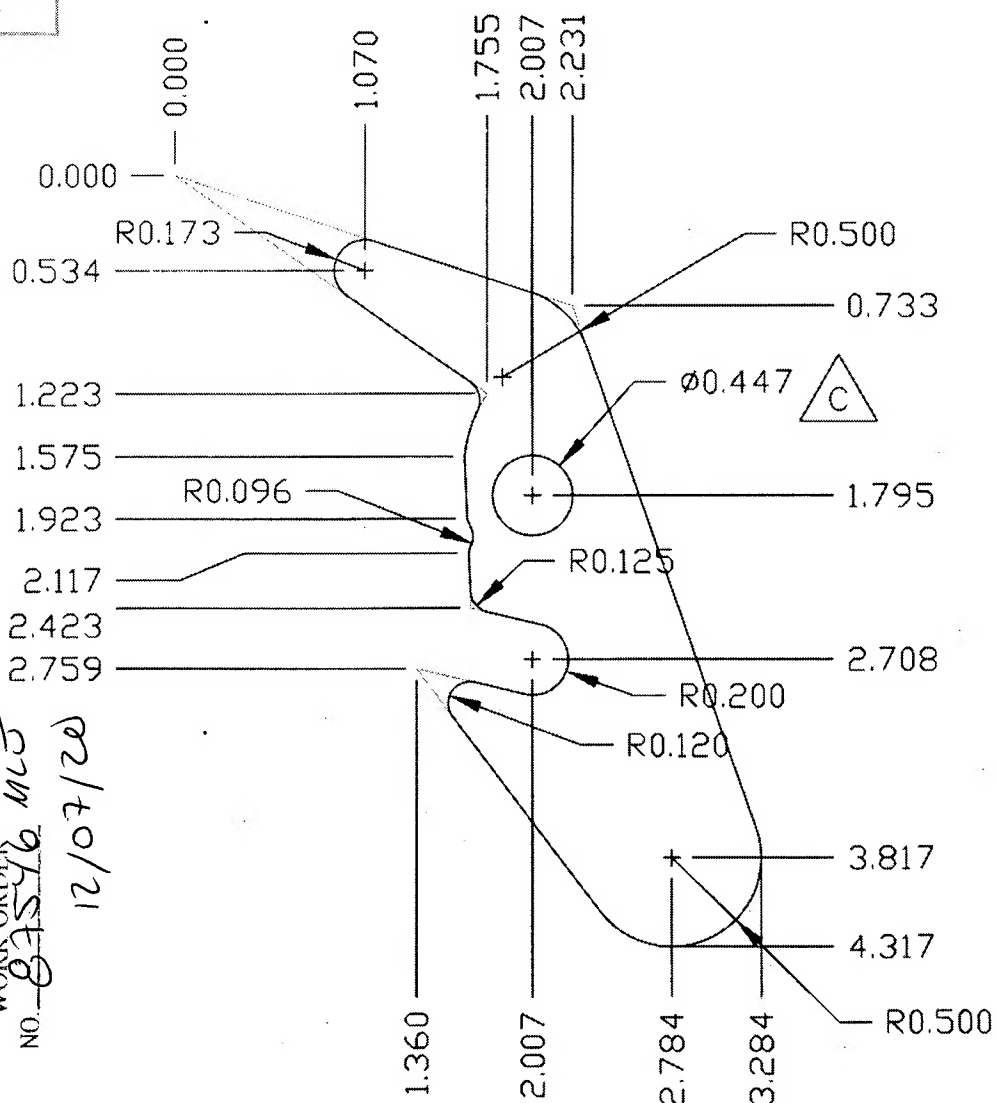
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *87546**12/07/20***D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED